



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4766-041
Job Sheet 201288



Part No: D4766-041

Job Qty: 1 pcs

Part Name: Skidtube Assembly

Part Weight: 0 lbs

Job Created: 9/30/19

Due Date: 11/1/19

Type: AOG

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG D4766 REV.F IPP REV:A 13.04.17 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB2 DD VERF:JLM
IPP REV:B 13.08.26 RB3 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM IPP
REV:D 15.06.10 AS PER DWG REV.C DD VERF:JLM IPP REV:E 16.03.23 AS PER DWG REV.D DD
VERF:JLM IPP REV:F 19.09.18 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sl
120	Skidtubes - 1	1 pcs		11/1/19	0.00	1.00	Skidtubes - 1		DD
						3.6	Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		BE
							Skidtubes - 6		
							Skidtubes - 7		
140	QC 5	1 pcs		11/1/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		00
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
150	Handfinish - 1-1 Chemical-B4B	1 pcs		11/1/19	0.00	0.62	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		00



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CANADA
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Email: sales@dartaero.com
www.dartaero.com

Container No: S223423

Part: D4766-041

Job No: 201288

Serial No/Batch: S223423

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/17/19

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					Handfinish - 1 - 4 - B4B						
					Handfinish - 1 - 5 - B4B						
					Handfinish - 1 - 6 - B4B						
					Handfinish - 1 - 7 - B4B						
					Handfinish - 1 - 8 - B4B						
					Handfinish - 1 - 9 - B4B						
					Handfinish - 1 - 10 - B4B						
					Handfinish - 1 - 11 - B4B						
					Handfinish - 1 - 12 - B4B						
					Handfinish - 1 - 13 - B4B						
					Handfinish - 1 - 14 - B4B						
					Handfinish - 1 - 15 - B4B						
					Handfinish - 1 - 16 - B4B						
					Handfinish - 1 - 17 - B4B						
					Handfinish - 1 - 18 - B4B						
					Handfinish - 1 - 19 - B4B						
					Handfinish - 1 - 20 - B4B						
					Handfinish - 1 - 21 - B4B						
					Handfinish - 1 - 22 - B4B						
					160 QC 7	1 pcs	11/1/19	0.00	0.00	QC 7 - 10	
										QC 7 - 13	
										QC 7 - 14	
										QC 7 - 15	
QC 7 - 17											
QC 7 - 18											
QC 7 - 19											
QC 7 - 2											
QC 7 - 28											
QC 7 - 3											
QC 7 - 30											
QC 7 - 34											
QC 7 - 36											
QC 7 - 37											
QC 7 - 41											
QC 7 - 47											
QC 7 - 48											
QC 7 - 51											
QC 7 - 58											
QC 7 - 59											
QC 7 - 60											
QC 7 - 9											
QC 7 - 68											
QC 7 - 50											
QC 7 - 67											
QC 7 - 40											
QC 7 - 24											
QC 7 - 43											
QC 7 - 61											
					Plex 9/30/19 1:54 PM Dart.lajeunesse						

Skidtubes - 3 - B4B	1 pcs	11/1/19	0.00 1.72	QC 7 - 81	
				QC 7 - 78	88
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MLG
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
180 QC 5	1 pcs	11/1/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
185 Skidtubes - 4 - B4B	1 pcs	11/1/19	0.00 3.44	Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MLG
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
188 QC 5	1 pcs	11/1/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 Handfinish - 2-1 Pressure-B4B	1 pcs	11/1/19	0.00 0.62	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	
220 Spray Paint - 2 - B4B	1	11/1/19	0.00 0.78		

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DAS
15

30 QC 14	1 pcs	11/1/19	0.00 0.00	Spray Paint - 2 - B4B	RD 19-11-15
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				QC 14 - 15	RD 19-11-15
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
260 Handfinish - 4-1-Assembly-B4B	1 pcs	11/1/19	0.00 0.62	Handfinish - 4 - 1 - B4B	RD 19-11-15
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
270 QC 5	1 pcs	11/1/19	0.00 0.00	Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
300 Packaging 3-1 - Stock - B4B	1 pcs	11/1/19	0.00 0.00	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

DAS
NOV 18 2019 68
9-89

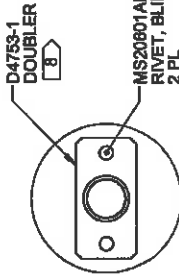
Plex 9/30/19 1:54 PM Dart.lajeunesse.marie

Part Specifications

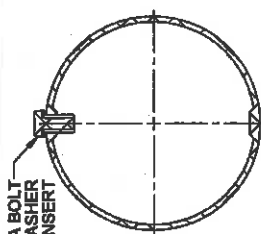
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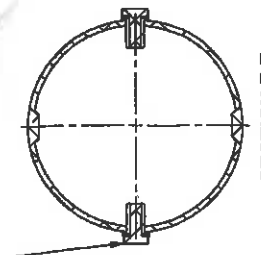
QTY	PIN	DESCRIPTION
1	D4766-043	SKIDTUBE SUB ASSY
11	D4686-1	SPACER
22	D4753-1	DOUBLER
1	D4766-045	SKIDTUBE SUB ASSY
2	D5304-1	CROSSBOLT SPACER
3	AELS-1032-130	INSERT
3	AN3C4A	BOLT
4	CR1122-3-02.5	RIVET, BLIND, CSK
44	MS20607AD4W3	RIVET, BLIND, CSK
2	MS21048L4	NUTPLATE
3	NAS1149C0332R	WASHER



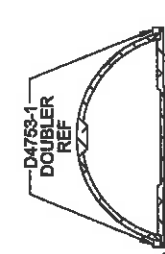
DETAIL E
SCALE 8X
22 PL



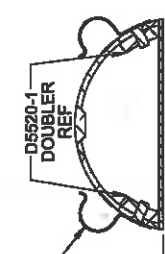
SECTION D-D
SCALE 8X



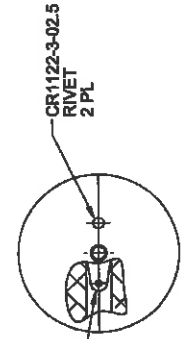
SECTION F-F
SCALE 8X



SECTION C-C
SCALE 8X
11 PL



SECTION G-G
SCALE 8X
2 PL



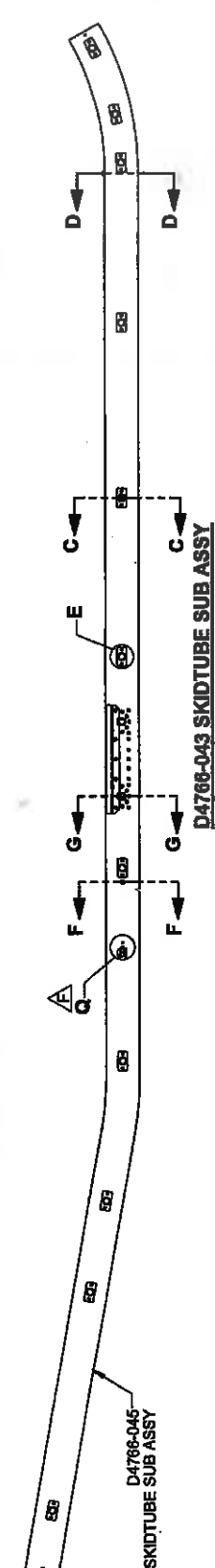
DETAIL Q
SCALE 8X
BOTH SIDES

INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS AS FOLLOWS:

1. REAM $\phi 0.758$ THRU DOUBLERS AND SKIDTUBE.
2. INSERT D4686-1 SPACER
3. SWAGE TO $\phi 0.680 / 0.650$ X 1.0 DP EACH SIDE PER DART QSI 002
4. TRIM/GRIND SPACER FLUSH WITH DOUBLER PER QSI 002

INSTALL D5304-1 CROSSBOLT SPACER AFTER INSTALLING D5520-1 DOUBLERS AS FOLLOWS:

1. OPEN PILOT HOLES THRU SKIDTUBE AND DOUBLERS TO $\phi 0.758$
2. INSERT D5304-1 CROSSBOLT SPACER
3. SWAGE TO $\phi 0.570 / 0.565$ X 1.0 DP EACH SIDE PER DART QSI 002
4. OPEN HOLE THRU SPACER TO $\phi 0.625$



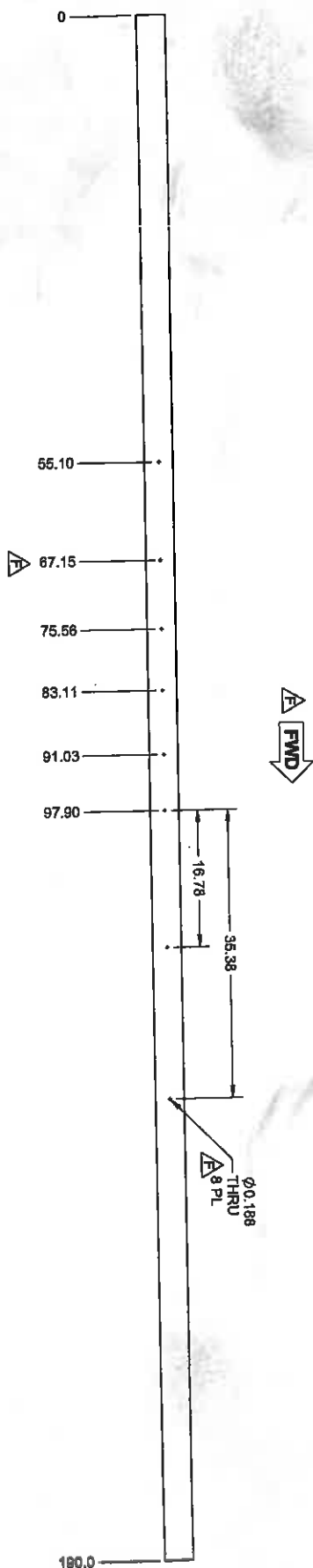
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 33.9 lbs
 - 8) SEAL FAYING SURFACES USING PROSEAL P/S 800/1422 OR MIL-S-8802 CLASS B2 SEALANT

RELEASED
2019 SEP 10 N/O

DESIGN	AP	AP	DART AEROSPACE USA, INC.	
DRAWN	ZF	MW	HILLSBORO, OR	
CHECKED	DD	NO	DRAWING NO. D4766	
MFG. APPR.	DE APPR.	DATE	18.11.22	
TITLE			SKIDTUBE	
REV. F			SHEET 9 OF 7	
SCALE			NTS	



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D4766-1 SKIDTUBE

- NOTES:**
- 1) MATERIAL: MAKE FROM D2962-110 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 006 4.1
 - 3) TOLERANCES: PER DART OSI 011 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER OSI 044 METHOD 6.4
- WEIGHT: 19.5 lbs

RELEASED
2019 SEP 10 10

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC.
DRAWN	ZF	HILLSBORO, OR
CHECKED	MW	DRAWING NO. D4766
ING. APPR.	DD	REV. F
APPROVED	NO	SHEET 7 OF 7
DATE	18.11.22	SCALE NTS
		TITLE SKIDTUBE

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Entered: _____ Date: _____

NCR No. _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: _____
Part No. _____

DISPOSITION
Rework ☐
Scrap ☐
Use-as-is ☐

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

- Operator ☐
- Manufacturing Process ☐
- Equip/Tooling ☐
- Handling/Preservation ☐
- Material ☐
- Product Improvement ☐
- Process Improvement ☐
- Human Factors ☐

FAULT CATEGORY

- Pressure/Forced ☐
- Bending ☐
- Crushing ☐
- Cracks ☐
- Crimp/Kink/Ripple/Wave/Twist ☐
- Marks/Chatter ☐
- Mislabeled ☐
- Contamination ☐
- Misaligned/off center ☐
- BOM/Route ☐
- Broken/Damage/Defect ☐
- Incomplete/Unclear Instructions ☐
- Drill Holes ☐
- Fit/Function ☐
- Power Loss/Surge ☐
- Folio/Program ☐
- Grain Direction ☐
- Weld ☐
- Wrong Stock Pulled ☐
- Out of Sequence ☐
- Off-set/Set-up ☐

- Positioned Wrong ☐
- Outside Tolerance ☐
- Drawing ☐
- Finish ☐
- Part Lost/Missing ☐
- Misread ☐

Other/Details: